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D3622-5

Job Sheet 182567



Part No: D3622-5

Part Name: Ball Stud



Part Weight: 0 lbs

Job Created: 8/28/18

Due Date: 8/31/18

Type: SOLD

Note: DWG REV D IPP REV:A NEW ISSUE 10-09-23 JLM VERIFIED BY:DD

Ship Via:

Job Qty: 10 ea

30 ea 10 ea
DAS
21
9-29

Status: Scheduled

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	8/31/18	8/31/18	0.00	0.00	Start Up Machining-2		JRD 2018/9/10
100	Hardinge	10 pcs	8/31/18	8/31/18	0.00	1.73	Hardinge		
110	QC	10 pcs	8/31/18	8/31/18	0.00	0.00	QC2 Machining-2		
120	QC	10 pcs	8/31/18	8/31/18	0.00	0.00	QC8 Machining-2		SL 18-9-11
130	Packaging	10 pcs	8/31/18	8/31/18	0.00	0.00	Packaging3-1		21 SEP 11 2018
140	QC21-SA	10 Ea	8/31/18	8/31/18	0.00	0.00	QC21		21 SEP 11 2018

Part Op
Descriptions: 100 - 1-TURN AS PER FOLIO F966 & DWG D3622 ,

21
9-29

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303H0.500	303 Hex Bar .500	1.0800 ft (.108 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303H0.500	1	32	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

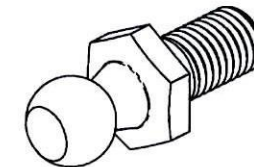
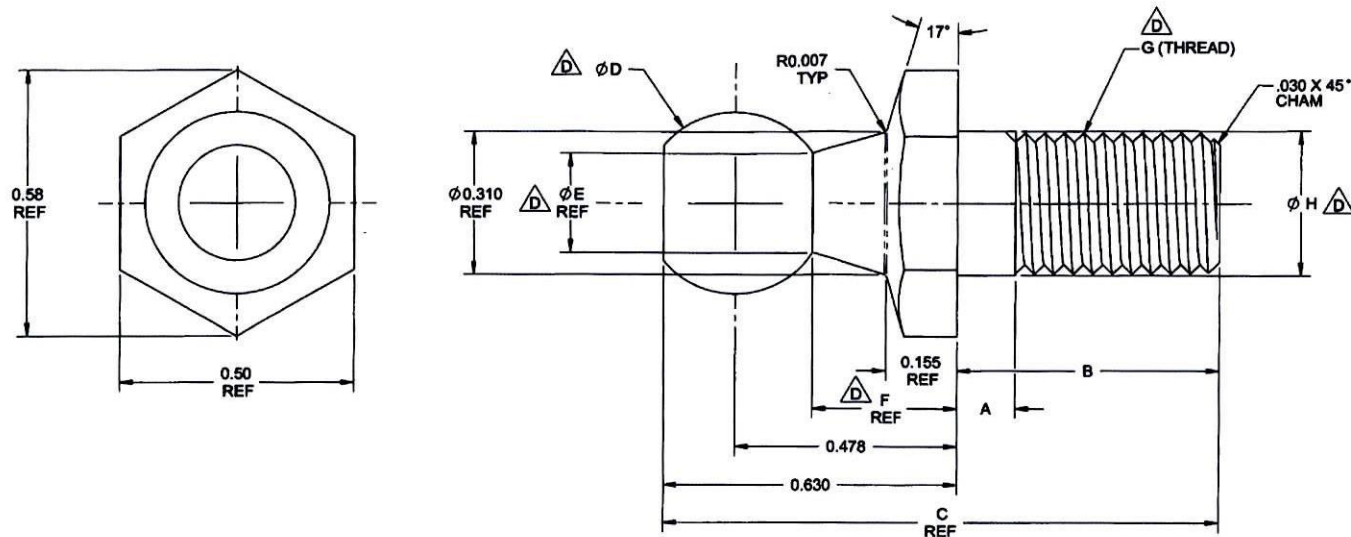


QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____ Date : _____ _____ _____	DISPOSITION Rework ☐	Skid-tube ☐ Cross tube ☐	Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐	Engineering ☐ Quality ☐ Other ☐	
Part: D3622-5 Job No: 182567 Serial No/Batch: S108897 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 09/10/18 Container No: S108897 DART AEROSPACE 1270 Aberdeen Street Hamilton, ON K6A 1K7 CANADA TEL: 1 513 632-5200 Email: sales@dartaero.com www.dartaerospace.com			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Root					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

8 7 6 5 4 3 2 1



D3622-1 BALL STUD SHOWN



D3622-11 BALL STUD SHOWN

PART NUMBER	DIM A	DIM B	DIM C	DIM D	DIM E	DIM F	WEIGHT (LBS)	THREAD G	MIN Ø H	MAX
D3622-1	0.125	0.583	1.19	0.394	0.215	0.313	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-3	0.125	0.583	1.19	0.394	0.215	0.313	0.03	0.1875-32UNF-3A	0.1840	0.1900
D3622-5	0.090	0.900	1.53	0.394	0.215	0.313	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-7	0.060	0.330	0.96	0.394	0.215	0.313	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-9	0.090	1.160	1.79	0.394	0.215	0.313	0.04	0.3125-24UNF-3A	0.3053	0.3125
D3622-11	0.060	N/A	0.69	0.394	0.215	0.313	0.02	NOT THREADED	0.270	0.300
D3622-13	0.090	0.680	1.31	0.394	0.215	0.313	0.03	0.3125-24UNF-3A	0.3053	0.3125
D3622-15	0.090	0.430	1.06	0.350	0.202	0.334	0.02	M6 X 1.0	5.82mm	6.00mm

D3622-X BALL STUD

NOTES:

- 1) MATERIAL: AISI 303 HEX BAR
REF DART SPEC M303H0.500
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D3622-X & B/N PER QSI 044
- 7) WEIGHT: SEE D3622-X TABLE

RELEASED
2016-04-18
ECN 16-557

APPROVED

D	ADDED -15. ADDED COLUMN D, E AND F. RENAMED SUBSEQUENT COLUMNS.	AK	16.03.15
C	SHEET 1: ADD -5, -7, -9, -11 & -13. ADD D3622-X TABLE. SHEET 2 DELETED	JPH	10.07.20
B	ADD -3 (SHEET 2)	HS	09.09.16
A	NEW ISSUE	MB	07.04.13
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	AK	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. D
MFG. APPR.	JL	D3622	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BALL STUD	NTS
DATE	16.03.15	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. WHO IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	